

Presentation Guideline for
Streamlined Inspection System

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Presentation Guideline for Streamlined Inspection System

The streamlined inspection system (SIS) for broilers and Cornish game hens was designed for optimum efficiency of inspection resources with confidence in inspection maintained by the agency, industry or consumers.

For the streamlined inspection system to meet these objectives, consistent postmortem presentation is a must. The inspector-in-charge (IIC) is responsible for applying objective presentation standards and requiring that they be met. This guideline is provided to assist the IIC in applying and maintaining reasonable and achievable standards for presentation. The guideline will be used by agency supervision to evaluate the IIC's presentation standards. It will also provide the agency with a tool to create a more uniform presentation nationwide.

The importance of good, consistent postmortem presentation cannot be overstressed when one appreciates the time and motion study applied to the design of this streamlined inspection procedure. Without consistent acceptable postmortem presentation, the inspector will not be able to carry out the inspection responsibilities at optimum line speed and the agency would be forced back into a subjective mode in order to control the process. The agency is convinced that process control is an industry responsibility and no one else can do it better. This guideline provides the ground rules for demonstrating the industry's process control at presentation.

The use of this guideline will aid the industry in understanding the importance of presentation and allow them the opportunity to control their presentation prior to the IIC assuming control.

These guidelines are designed for the inspection team but may also be used by the plant as a guide for developing a process control program for presentation.

The process control program would give the IIC additional confidence in the plant's ability to control its presentation and reduce inspection's monitoring frequency and process actions.

Test Description: Each processing line and all inspection stations must be monitored for presentation effectiveness. Ten-bird checks are used to measure this effectiveness. The 10-bird check consists of two separate observations, one for outside errors and the second for inside errors. Each error has been measured for its effect on the inspector and assigned a weighted factor per error. The total of the weighted errors on both inside and outside observation provides the measure of presentation acceptability.

The outside observation will be made first. This observation must be made at each inspection station. It will be made offline, behind and between the presenter with birds on the kickout and prior to the inspector. The outside of 10 online birds will be checked for all of the listed *outside* errors. Each error observed will be recorded. Then, at the same station, but online between the presenter and the inspector, 10 additional birds will be observed for listed *inside* errors. Each inside error will be then recorded.

The last part of all checks is the line speed check. The outside and inside errors are converted to a weighted score and added to any line speed error to determine the total nonconformance for each station.

Presentation checks are procedures that are either scheduled or unscheduled under the Performance Based Inspection System (PBIS).

A plant desiring to establish slaughter process control and reduce inspection control of presentation may want to have production personnel control the process. If so, management may want to seek the presentation rules for the New Line Speed Inspection System (NELS) from the district office to be used as a guideline to establish good slaughter process control. A copy of the plant slaughter process control program for presentation should be made available to the IIC upon request to review for compliance with agency guidelines.

SIS Carcass Presentation Description of Errors

I. Outside Carcass Errors (Observe 10-bird sample offline at each inspection station.)

A. Front or side - weight of 11

Birds arriving with other than the back of the bird toward the inspector.

B. Not hung by two legs - weight of 9

Birds arriving with both legs not properly suspended in the shackle.

C. Birds swinging - weight of 6

Birds arriving with sufficient swinging motion to interfere with the inspection process.

D. Viscera not uniform - weight of 8

Birds arriving with viscera on the opposite side of normal presentation; in the middle of the abdominal opening; or with the membrane attached to the abdominal opening and tail, which interferes with the viscera observation.

E. Contaminated viscera - weight of 6

Birds arriving with contaminated viscera which may affect postmortem inspection effectiveness or efficiency.

F. Viscera below wing - weight of 12

Birds arriving with the visceral organs below the wing breast joint.

- G. Viscera not free - weight of 10

Birds arriving with viscera not free of fat and suspended along side the carcass.
- H. Viscera in shackle - weight of 8

Birds arriving with visceral organs hung in the shackle.
- I. Out of sequence - weight of 15

Birds arriving on guide bar out of sequence for the inspection station due to kick out malfunction.
- J. No viscera - weight of 20

Birds arriving without viscera.
- II. Inside Carcass Errors (Observe 10-bird sample online at each inspection station.)
 - A. Membrane - weight of 2

Birds arriving with inside cavity obstructed by air sac membranes from viscera to cavity.
 - B. Opening cut - weight of 1

Birds arriving with inside cavity obstructed by inadequate opening cut. Opening cut should be sufficient to allow adequate inspection of the insides of the carcass. It has been found that a cut made within 1/2 - 3/4 inch of point of the keel is an adequate opening.
 - C. Not reflected - weight of 2

Birds arriving with the viscera not reflecting the appropriate abdominal flap.
 - D. Parts inside - weight of 1

Birds arriving with one or more of the visceral organs left in the cavity.
 - E. Contamination inside - weight of 6

Birds arriving with contamination occurring on the inside surfaces of the carcass.
 - F. Mutilation - weight of 2

Birds arriving mutilated by the vent or evisceration equipment which may affect inspection efficiency.

III. Line Speed Error (Counted after completion of all inspection station checks on the line.)

Line speed exceeding current maximum for their production capability during a specific period of time. Each bird per minute (bpm) exceeding the current maximum equals one error and is calculated in the total nonconformance weight. Line speed errors are not included in the category of "same or identical errors".

Example: If the line speed exceeds the maximum of 70 bpm on any check, immediate line speed reduction is required. Each bpm exceeding the maximum of 70 is counted as a presentation error with a weight of 5.

Example: If the line had been slowed to 63 bpm by the previous check and the next check shows a line speed of 66 bpm, the line is immediately slowed to 63 bpm. The 3 bpm count as 3 errors with a weight of 5 each or a total error weight of 15 for this recheck. The 3 line speed errors, however, would not count as 3 occurrences of the same error.

The following categories of birds will be signaled for hangback by the inspector and be hung back by the inspector's helper; no error will be recorded on a presentation check for:

- A. Not opened - Bird arrives at inspection station with no opening cut made in the carcass.
- B. Not drawn - Bird arrives at the inspection station with opening cut made but with viscera drawn insufficiently to permit inspection.
- C. Two legs out of shackle - Bird arrives at inspection station hung by head, neck or wing.

Hung-back birds can cause process problems that if not addressed may result in unwholesome product being produced. Ongoing rework of the hangback rack to correct birds and place them back into the product flow is a must to protect the product's integrity. The number of birds being hung back for lack of proper presentation must be held to a minimum, with ongoing rework of hangback racks to assure wholesomeness of the product.

Suggested actions for these presentation rules are: required retest to verify previous sample within 10 minutes and/or required line speed reduction until presentation control is demonstrated. Which action(s) taken is determined by the total nonconformance weight of the 10-bird check and the maximum number of the same individual presentation error on a check.

If any 10-bird check has a total nonconformance weight of 40 or more, immediate line reduction action must be taken. Line speed reductions are based on 10% of the bpm from the current line speed at the time of the check. A 10% line speed change is the figure determined to be required to allow adequate inspection. It is also the point in production increase where process control again needs to be demonstrated. If the line speed at the time of check is 70 and line speed reduction is required, then minimum reduction is 7 bpm. A retest at reduced line speed after failed presentation is required within 10 minutes.

If any 10-bird total nonconformance weight is 25 through 39, the plant is required to take immediate corrective action, and the IIC will retest all stations on the line within 10 minutes.

If any station *retest* is 25 or more, the line speed must be reduced 10%. All stations on the line are checked again within 10 minutes after line reduction action to measure presentation acceptance level at the reduced speed. Another important observation that must be made after each check and retest is the number of identical errors on the same test. If any check of a 10-bird test shows 3 or more of the same presentation error, the plant must take immediate corrective action and retest within 10 minutes. If any retest results in 3 or more of the same error or a total nonconformance weight of 25 or more, the line speed must be reduced 10%.

Line speed reductions of 10% continue on each retest until a total of 24 or less and 2 or less of any one error is achieved or the third line speed reduction in a row for presentation has taken place. When three consecutive line speed reductions for presentation on nonconformance on one line do not result in acceptable presentation on that line, the IIC must evaluate the presentation problem. The IIC will determine the effect the presentation problem is having on postmortem inspection and operational sanitation. Presentation guidelines were established based on optimum line speeds. Acceptable presentation at less than 70% of optimum line speed will be determined by the IIC. The line speed will be allowed to increase from its current rate in the same increments (bpm) as it was reduced up to the maximum allowed only after presentation control (24 or less and 2 or less incidences of the same error) has been demonstrated.

Example: If the line speed had been decreased as follows: 70 to 63, 63 to 56 and 56 to 50 bpm, it would be increased in the same bpm as it was decreased, i.e., 50 to 56, 56 to 63 and 63 to 70 bpm.

With each line speed increase, process control must again be demonstrated at each station at the higher line speed 10 minutes after the increase.

When the line speed has been increased to the maximum allowable 70 bpm, process control must be demonstrated at each station 10 minutes after the increase.

All actions generated by presentation checks will be the responsibility of the IIC unless the plant has established a quality control program to control this process. If the plant has a quality control program for presentation, then the inspector will monitor the plant's action to assure program requirements are met using presentation rules for the NELS inspection system.

Because of differences in plant staffing and supervision, the presentation results of each shift and each production day will be independent of all other presentation results. There will be a new presentation form and a new start for each station each shift and each production day.